

Date Wednesday, 15/08/2007 4:07:21 PM
 User Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 33969
 Estimate Number : 12674
 P.C. Number : N/A
 This Issue : 15/08/2007 S.O. No. : N/A
 Prsh Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 32830
 Written By : JLM 07-08-16
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-01-29 JLM

Drawing Name : ADAPTER
 Part Number : D35733
 Drawing Number : D3573 REV.A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 01/09/2007
 Qty: 30
 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X02500	6061-T6 Bar .50" x 2.5"
	Comment: Qty.: 0.3066 f(s)/Unit Total : 4.5990 f(s) 6061-T6 Bar .50" x 2.5" Batch: M104366	 JML 07/08/24 30
2.0	BAND SAW	BAND SAW
	Comment: BAND SAW Cut blank 3.500" long	 JML 07/08/24 30
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA673 and Dwg D3573	 JML / J.F. 07/08/25 (30)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	 JML / J.F. 07/08/25 (30)
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	 86 07/08/25 / (30)
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	 JML 07-08-27 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 11/01/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:07:22 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADAPTER

Job Number: 33969

Part Number: D35733

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 POWDER COATING

POWDER COATING



M 10484



30x

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-f 07/08/27

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



7/08/28(30) W

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/08/28(30)



(30)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



30

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



7/08/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

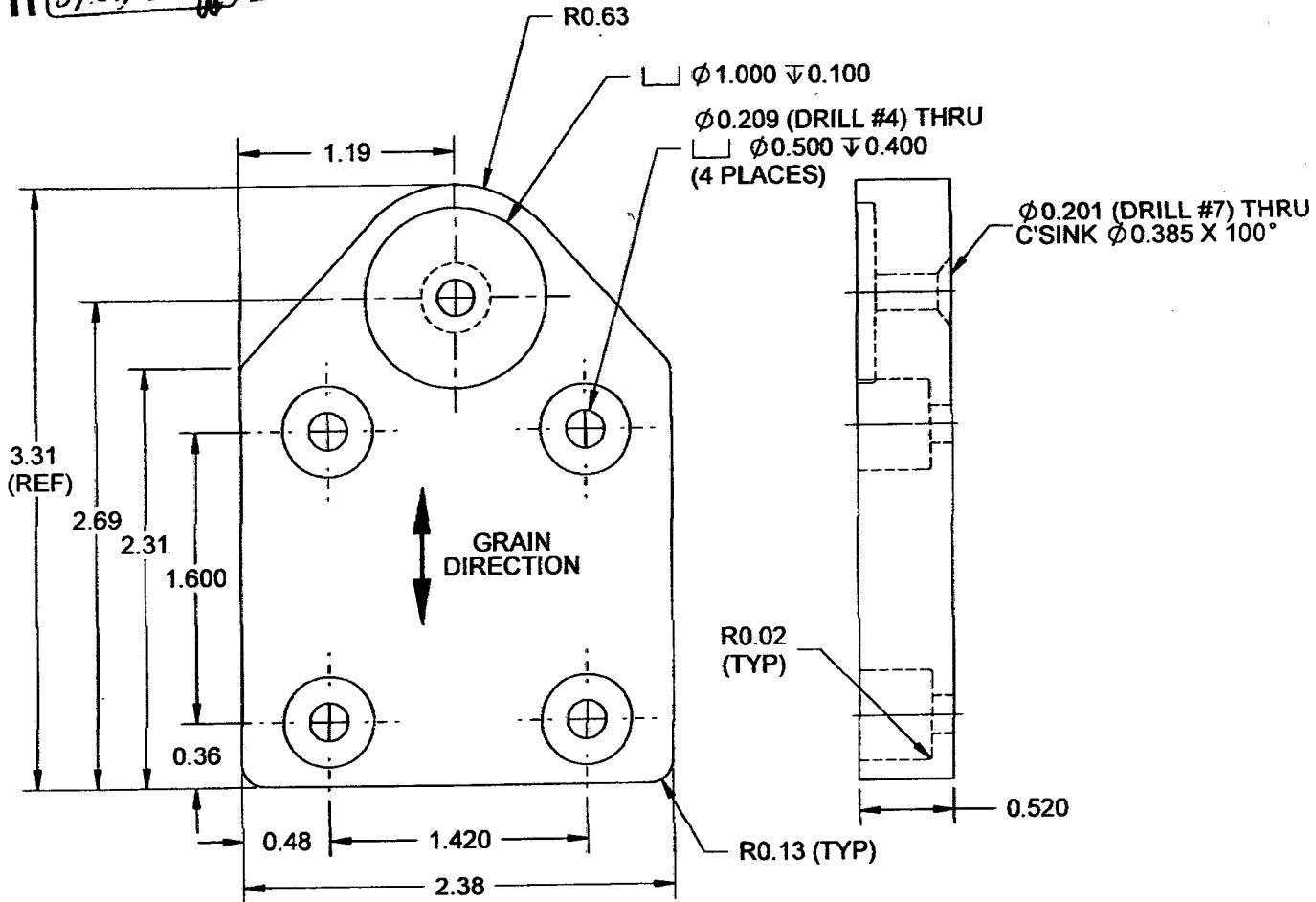
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. D3573	REV. A SHEET 1 OF 4
DATE 07.02.19		TITLE ADAPTER	SCALE 1:1
REV A	DATE 07.02.19	DESCRIPTION NEW ISSUE	

RELEASED
07-03-22**D3573-1 ADAPTER****NOTES:**

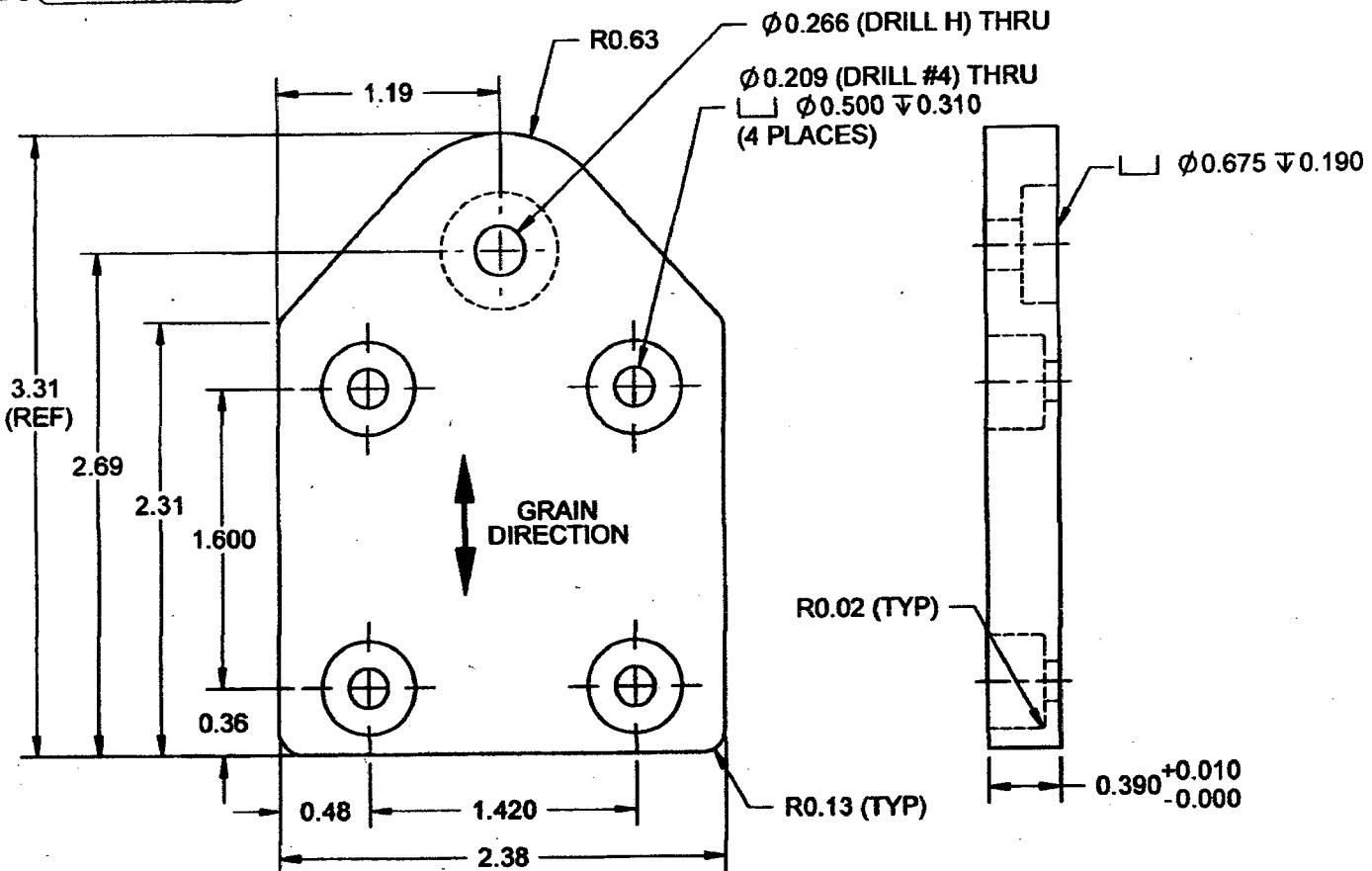
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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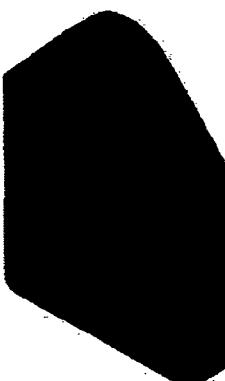
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DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>SH</i>	DRAWING NO. D3573	REV. A SHEET 2 OF 4
DATE 07.02.19	TITLE ADAPTER	SCALE 1:1	

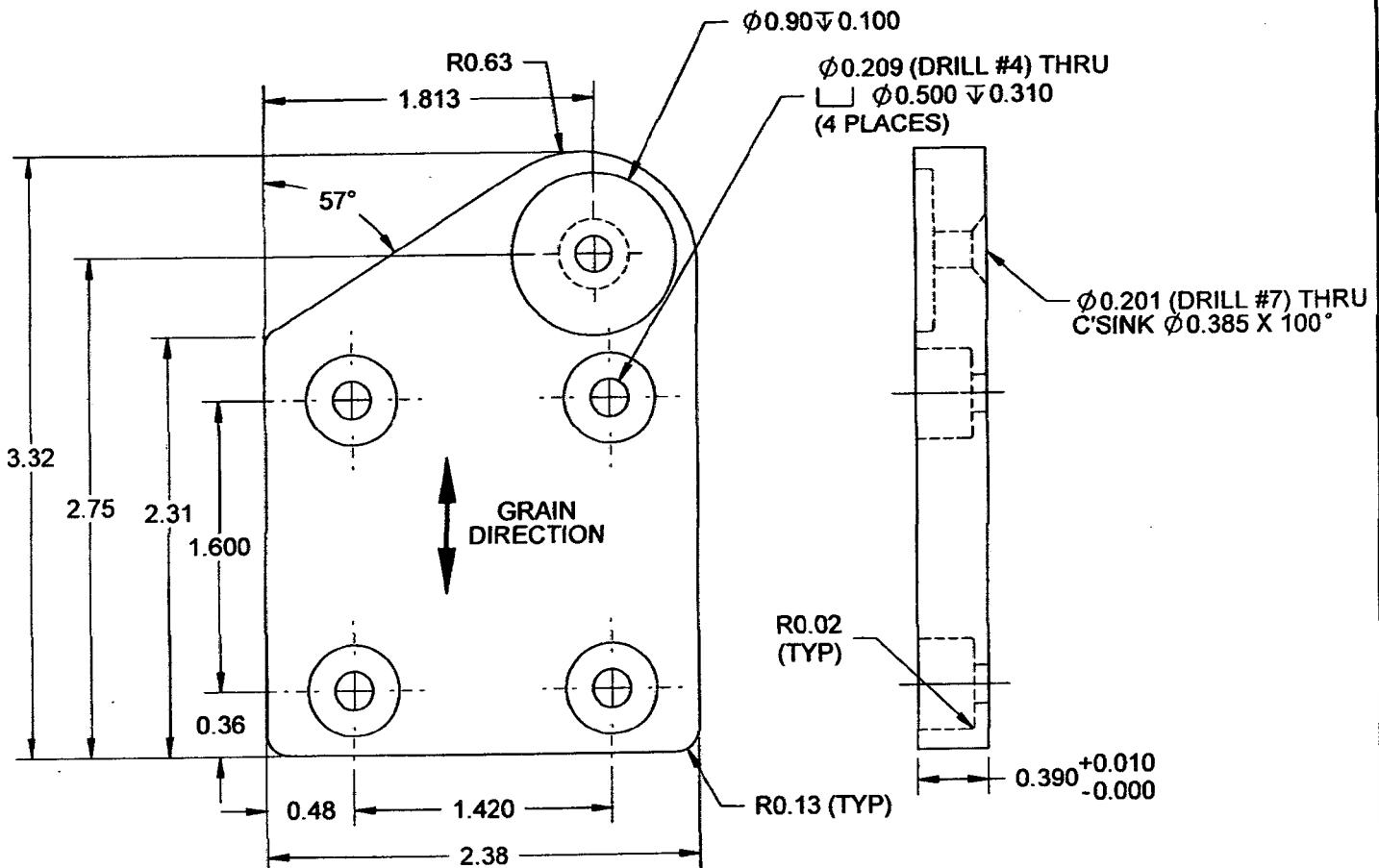
RELEASED
07.04.02**D3573-3 ADAPTER****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

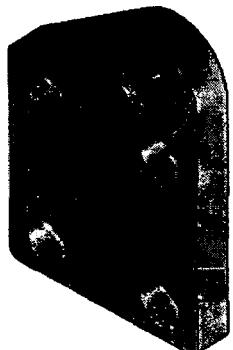


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DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3573	REV. A SHEET 4 OF 4
DATE 07.02.19		TITLE ADAPTER	SCALE 1:1

RELEASED
07.04.02 *[initials]*

D3573-7 ADAPTER (SHOWN)
D3573-8 ADAPTER (OPPOSITE)



NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD	Work Order:	33969
Description: ADAPTER	Part Number:	03573-3
Inspection Dwg: 03573 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
$\phi 0.675$	$\pm .010$	$\phi 0.682$	—			
$\text{I} 0.190$	$\pm .016$	$\text{I}.190$	—			
0.396	$\pm .008$	0.395	—			
$R 0.02$	$\pm .030$	$R 0.020$	—			
$R 0.13$	$\pm .030$	$R 0.136$	—			
2.38	$\pm .036$	2.377	—			
1.420	$\pm .005$	1.420	—			
0.48	$\pm .030$	0.480	—			
0.36	$\pm .030$	0.358	—			
1.600	$\pm .005$	1.600	—			
2.69	$\pm .036$	2.687	—			
3.31	$\pm .086$	3.313	—			
1.19	$\pm .036$	1.190	—			
$\phi 0.266$	$\pm .004$ $\pm .001$	$\phi 0.266$	—			
$\phi 0.201$	$\pm .005$ $\pm .001$	$\phi 0.210$	—			
$\phi 0.500$	$\pm .016$	$\phi 0.497$	—			
$\text{I} 0.310$	$\pm .016$	$\text{I}.310$	—			

Measured by:	<i>DNL</i>	Audited by:		Prototype Approval:	
Date:	07/08/24	Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	